

8/7/18

[Dart Hawkesbury] Job Sheet - Leroux, Jason

NCR 19-7641

S110296



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

646.9602

Job Sheet 181713



Part No: 646.9602

Job Qty: 2 ea

Part Name: Lower Cutter Assembly High



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/7/18

Job Tracking No:

Created By: Jason Leroux

Due Date: 8/10/18

Description:

Type: Stock

Note: DWG REV M/C IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off      |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|---------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |               |
| 90    | Start up Operation | 2 Ea  |            | 8/10/18  | 0.00      | 0.00    | Start Up Stores/Pkg-2 |           |               |
| 110   | Packaging          | 2 pcs |            | 8/10/18  | 0.00      | 0.00    | Packaging1-1          |           |               |
| 120   | Small Fab          | 2 pcs |            | 8/10/18  | 0.00      | 0.05    | Small Fab-1           |           |               |
| 130   | QC                 | 2 pcs |            | 8/10/18  | 0.00      | 0.00    | QC5                   |           | DAS           |
| 140   | Packaging          | 2 pcs |            | 8/10/18  | 0.00      | 0.00    | Packaging3-1          |           | DAS           |
| 150   | QC21-SA            | 2 Ea  |            | 8/10/18  | 0.00      | 0.00    | QC21                  |           | 6 SEP 22 2018 |

Part Op 120 - Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2. A/R RTV LOCTITE  
Descriptions: 598: exp. date:

140 - \*\*\*IDENTIFY AS PER IAW MPP-120\*\*\*

## Job BOM

| Part / Item   | Component Name         | Quantity     | Operation             | Container |
|---------------|------------------------|--------------|-----------------------|-----------|
| 646.9701      | Cutter Sub Assembly    | 2 Ea (1 ea)  | 90-Start up Operation | 5076165   |
| 646.9812      | Lower Cutter Deflector | 2 Ea (1 ea)  | 90-Start up Operation | 50229547  |
| MS21042L08    | Nut                    | 6 Ea (3 ea)  | 90-Start up Operation | 5644234   |
| MS27039-08-19 | Screw                  | 6 Ea (3 ea)  | 90-Start up Operation | 5044235   |
| NAS1149FN832P | Washer                 | 12 Ea (6 ea) | 90-Start up Operation | 5084896   |

## Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | 646.9701       | 2        | 2         | 0         |
|                       | 646.9812       | 2        | 15        | 0         |
|                       | MS21042L08     | 6        | 1,164     | 0         |
|                       | MS27039-08-19  | 6        | 654       | 0         |
|                       | NAS1149FN832P  | 12       | 590       | 0         |

## Part Specifications

Specifications could not be found.

Plex 8/7/18 11:22 AM dart.leroux.jason

200 Aurora Industrial Pkwy  
Aurora OH 44202-8087  
330-995-5500  
cle.sales@mcmaster.com

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawkesbury ON K6A 1K7  
Canada

Purchase Order  
**POHB046921**

Order Placed By  
**Kim**

McMaster-Carr Number  
**1717483-03**

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08/24/2020

| Line                                                     | Product                                                                                                                  | Ordered   | Shipped |
|----------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------|-----------|---------|
| 3                                                        | 5507A832 T-Handle Slip-Release Factory-Set Wrench, Torque in ft.-lbs. , Ratchet, 3/8" Square Drive, 5-3/8" LG, TORQ=10.0 | 1<br>Each | 1       |
| Shipped separately from our Cleveland warehouse on 08/17 |                                                                                                                          |           |         |
| 1                                                        | 92620A231 Zinc Yellow-Chromate Plated Hex Head Screw, Grade 8 Steel, 1/2"-13 Thread Size, 7-1/2" Long                    | 1<br>Pack | 1       |
| 2                                                        | 89315A43 TiN-Coated High-Speed Steel Multidiameter Drill Bit, 9 Inch Sizes                                               | 2<br>Each | 2       |
| 4                                                        | 85555A311 Adjustable Torque Wrench with Certificate, Ratcheting, 3/8" Drive, 5-75 ft.-lbs. and 10.2-98.3 NM              | 1<br>Each | 1       |
| 5                                                        | 5849A74 6-Point Deep Socket, 3/8" Square Drive, 20mm Size                                                                | 1<br>Each | 1       |
| 6                                                        | 53385A12 Nonmarring Pick, Blunt and Straight Tips, 6" Overall Length                                                     | 1<br>Pack | 1       |
| 7                                                        | 3461K41 Ultrasonic Cleaner, Programmable and Heated, 3 qt. Capacity                                                      | 1<br>Each | 1       |
| 8                                                        | 7573T66 Heavy Duty Compartmented Drawer Cabinet, Bench Height, with 6 Drawers, 34" High x 23" Wide x 29" Deep, Blue      | 1<br>Each | 1       |

## Certificate of compliance

This is to certify that the above items were supplied in accordance with the description and as illustrated in the catalog. Your order is subject only to our terms and conditions, available at [www.mcmaster.com](http://www.mcmaster.com) or from our Sales Department.

1-box

PURCHASE # CPK008015436

*Sarah Weinberg*

Sarah Weinberg  
Compliance Manager

*[Signature]*



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

# **PURCHASE ORDER** **POHB046921**



**Supplier:** MCM001-VU  
McMaster-Carr Supply Co,  
P.O. Box 7690  
Chicago, IL 60680-7690 USA  
Phone: 330 995 5500  
Fax: 330 995 9600

**Attention:** N/A,

**Ship To:** 1270 Aberdeen Street  
Hawkesbury  
ON  
K6A 1K7 Canada  
Phone: 613-632-5200

**PO No:** POHB046921

**PO Date:** 8/17/20

**Due Date:** 8/19/20

**Purchase Order**

**Revision:**

**Revision Date:**

**Issued By:** Guerin, Kimberley  
Phone: 613-632-5200 Ext: 298  
kguerin@dartaero.com

**Via:** Ground

**Pynt Terms:** Net 60

**Freight Terms:**

**Special Comments:**

## Items

| Line Item              | Job | Part | Drawing | Supplier Part No | Item No                            | Description                                                                                           | Status       | Account        | Due Date | Order Quantity | Received Quantity | Balance | Unit Price (USD) | Extended Price |
|------------------------|-----|------|---------|------------------|------------------------------------|-------------------------------------------------------------------------------------------------------|--------------|----------------|----------|----------------|-------------------|---------|------------------|----------------|
| 3                      |     |      |         | 5507A832         | Small Tools and Insert-Maintenance | T-Handle Slip-Release Factory-Set Wrench, Torque in ft.-lbs., Ratchet, 3/8" Square Drive, 5-3/8" Long | Firmed<br>X1 | 16018-000-0000 | 8/19/20  | 1 Ea           | 0 Ea              | 1 Ea    | \$333.53/Ea      | \$333.53       |
| AUG 26 2020            |     |      |         |                  |                                    |                                                                                                       |              |                |          |                |                   |         |                  |                |
| Line Item Note David F |     |      |         |                  |                                    |                                                                                                       |              |                |          |                |                   |         |                  |                |
| <b>Grand Total:</b>    |     |      |         |                  |                                    |                                                                                                       |              |                |          |                |                   |         | <b>\$333.53</b>  |                |

## Order Notes

Procurement Quality clauses

A000, not required

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit [www.dartaerospace.com](http://www.dartaerospace.com) for further explanation.

Plex 8/26/20 2:57 PM dart.charest.martin

DQA:

1R

Date:

Oct 20/19

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☐

|                                             |                                                |                                                 |                                                            |                                                                        |                                               |                                              |                                      |
|---------------------------------------------|------------------------------------------------|-------------------------------------------------|------------------------------------------------------------|------------------------------------------------------------------------|-----------------------------------------------|----------------------------------------------|--------------------------------------|
| Work Order: <u>181713</u>                   |                                                | <b>DISPOSITION</b>                              |                                                            | <b>AGAINST DEPARTMENT/PROCESS</b>                                      |                                               |                                              |                                      |
| Part No. <u>646.9602</u>                    |                                                | Rework <input type="checkbox"/>                 |                                                            | Skid-tube <input type="checkbox"/>                                     | Cross tube <input type="checkbox"/>           | Water Jet <input type="checkbox"/>           | Engineering <input type="checkbox"/> |
| NCR No. <u>19-7641</u>                      |                                                | Scrap <input type="checkbox"/>                  |                                                            | Machining <input type="checkbox"/>                                     | Small Fab <input checked="" type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/>   | Quality <input type="checkbox"/>     |
|                                             |                                                | Use-as-is <input checked="" type="checkbox"/>   |                                                            | Thermoforming <input type="checkbox"/>                                 | Finishing <input type="checkbox"/>            | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/>       |
|                                             |                                                | Suspected Unapproved <input type="checkbox"/>   |                                                            | Large Fab <input type="checkbox"/>                                     | Composite <input type="checkbox"/>            | Supplier <input type="checkbox"/>            |                                      |
| Date: <u>2019-07-19</u>                     |                                                | Step #:                                         |                                                            | QTY Effective: <u>2</u>                                                |                                               | MRB (QSI042) Approval                        |                                      |
| Description Work Order Deviation            |                                                |                                                 |                                                            | Disposition                                                            |                                               |                                              |                                      |
| install a 646.9812 instead of a 646.9811    |                                                |                                                 |                                                            | ID under 646.9602<br>Part manufactured as per.<br>Dwg.<br>NO DEVIATION |                                               |                                              |                                      |
|                                             |                                                |                                                 |                                                            | Completed By<br><u>SMB</u><br>19-07-19                                 |                                               |                                              |                                      |
|                                             |                                                |                                                 |                                                            | Lead hand / Supervisor<br>Approval Verification<br><u>JS</u> 19/07/19  |                                               |                                              |                                      |
|                                             |                                                |                                                 |                                                            | QC / QA Coordinator<br>Approval<br><u>55</u><br>9-89 19 JUL 2019       |                                               |                                              |                                      |
| <b>Root Cause</b>                           |                                                | <b>FAULT CATEGORY</b>                           |                                                            |                                                                        |                                               |                                              |                                      |
| Environment <input type="checkbox"/>        | No Re-verification <input type="checkbox"/>    | Pressure/Forced <input type="checkbox"/>        | Temperature/Cure <input type="checkbox"/>                  | Power Loss/Surge <input type="checkbox"/>                              | Positioned Wrong <input type="checkbox"/>     |                                              |                                      |
| Design <input type="checkbox"/>             | Operator <input type="checkbox"/>              | Bending <input type="checkbox"/>                | Set-up <input type="checkbox"/>                            | Folio/Program <input type="checkbox"/>                                 | Outside Dimensions <input type="checkbox"/>   |                                              |                                      |
| Doc/Data <input type="checkbox"/>           | Offset/Setup <input type="checkbox"/>          | Centre Not Concentric <input type="checkbox"/>  | BOM/Route <input type="checkbox"/>                         | Grain <input type="checkbox"/>                                         | Over/Under tolerance <input type="checkbox"/> |                                              |                                      |
| Equip/Tooling <input type="checkbox"/>      | Supplier <input type="checkbox"/>              | Cracks <input type="checkbox"/>                 | Broken/Damage/Defect <input type="checkbox"/>              | Weld <input type="checkbox"/>                                          | Part Incorrect <input type="checkbox"/>       |                                              |                                      |
| Handling/Pre <input type="checkbox"/>       | Training <input type="checkbox"/>              | Crimp/Kink/Ripple/Wave <input type="checkbox"/> | Inspection Incomplete/Unqualified <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/>                            | Part Lost/Missing <input type="checkbox"/>    |                                              |                                      |
| Material <input type="checkbox"/>           | Use for Testing <input type="checkbox"/>       | Cuffs <input type="checkbox"/>                  | Contamination <input type="checkbox"/>                     | Out of Sequence <input type="checkbox"/>                               | Part Moved <input type="checkbox"/>           |                                              |                                      |
| Internal Transport <input type="checkbox"/> | Poor Information <input type="checkbox"/>      | Crushing <input type="checkbox"/>               | Countersink <input type="checkbox"/>                       | Off-set <input type="checkbox"/>                                       | Drawing <input checked="" type="checkbox"/>   |                                              |                                      |
| Tribal Knowledge <input type="checkbox"/>   | Rushing <input type="checkbox"/>               | Heat Treat <input type="checkbox"/>             | Cut Too Short <input type="checkbox"/>                     | Mislabeled <input type="checkbox"/>                                    | Finish <input type="checkbox"/>               |                                              |                                      |
| LOA <input checked="" type="checkbox"/>     | Product Improvement <input type="checkbox"/>   | Wave/Twist in Tube <input type="checkbox"/>     | Instructions Incomplete/Unclear <input type="checkbox"/>   | Fit/Function <input type="checkbox"/>                                  | Misread <input type="checkbox"/>              |                                              |                                      |
| Substation <input type="checkbox"/>         | Process Improvement <input type="checkbox"/>   | Marks/Chatter <input type="checkbox"/>          | Drill Holes <input type="checkbox"/>                       | Misaligned/off center <input type="checkbox"/>                         | Turning Sequence <input type="checkbox"/>     |                                              |                                      |
| Past Expiry Date <input type="checkbox"/>   | Manufacturing Process <input type="checkbox"/> |                                                 |                                                            |                                                                        |                                               |                                              |                                      |
| Misidentified <input type="checkbox"/>      | Past Due <input type="checkbox"/>              | OTHER: <input type="checkbox"/>                 |                                                            |                                                                        |                                               |                                              |                                      |